

Date: Friday, 11/17/2006 9:07:56 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	: 29511		Part Number	: D2572		
Estimate Number	: 10531		Drawing Number	: D2572 REV E		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 11/17/2006	S.O. No. : N/A	Drawing Revision	: E		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 12/5/2006		
Previous Run	: 29160		Qty:	16	Um:	Each
Written By						
Checked & Approved By						
Comment	: Est: I 02.11.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101005	7075-T7351 8.25X5.0X2.5	
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: B25351			
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
<b>Comment:</b> HAAS CNC VERTICAL MACHINING #1 Program Batch No. 29510 Double check by: SD			
1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.			
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
<b>Comment:</b> CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/12/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/17/2006 9:07:56 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 29511

Part Number: D2572

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



SD / QM / En 06/11/28 (10)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK



JL 06/12/10 16

Comment: SECOND CHECK

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m

06/12/18

(lex)

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06/12/21

(16x)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

6/12/21 (16)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 351

EB 6/12/21 (16) 10/12/16

10.0 QC21 FINAL INSPECTION/W/O RELEASE



(16)

Comment: FINAL INSPECTION/W/O RELEASE

06/12/22

Job Completion



12/12/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 29511	
Description: Saddle, Fwd Inboard			Part Number: D2572		
Inspection Dwg: D2572 Rev. E			Page 1 of 1		

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	440	0.439	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.997	7.997	7.997	7.997		
F	0.490	0.510		-493	0.503	0.504	0.504		
G	0.257	0.262	DT8683	258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	376	0.376	0.377	0.376		
I	0.490	0.510		500	0.500	0.498	0.499		
J	1.174	1.184		1178	1.178	1.178	1.178		
K	0.558	0.578		568	0.569	0.569	0.569		
L	1.174	1.184		1179	1.178	1.178	1.178		
M	1.490	1.500		1495	1.494	1.495	1.496		
N	2.495	2.505		2500	2.498	2.500	2.500		
O	3.869	3.879		3877	3.873	3.875	3.873		
P	0.115	0.135		126	0.124	0.124	0.127		
Q	0.115	0.135		134	0.135	0.135	0.135		
R	0.240	0.260		256	0.250	0.250	0.251		
S	0.115	0.135		150	0.132	0.131	0.130		
T	0.178	0.198		188	0.188	0.188	0.188		
U	2.940	2.980		2955	2.960	2.960	2.960		
V	0.230	0.250		238	0.239	0.241	0.248		
W	0.115	0.135		125	0.120	0.126	0.129		
X	0.307	0.312		311	0.311	0.310	0.310		
Y	0.760	0.765		0.761	0.761	0.766	0.766		
Z	0.352	0.372		364	0.366	0.364	0.365		
AA	0.470	0.530		500	0.500	0.500	0.500		
AB	0.615	0.635		627	0.629	0.630	0.630		
AC	0.053	0.073		063	0.063	0.063	0.063		
AD	0.240	0.260		252	0.261	0.249	0.248		
AE	1.375	1.395		1385	1.380	1.382	1.380		
AF	0.115	0.135		133	0.135	0.135	0.135		
AG	0.240	0.280		275	0.260	0.260	0.260		
AH	0.240	0.260		253	0.248	0.250	0.248		
AI	2.000	2.020							
AJ	0.023	0.043		030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	SD / TML	Audited by:	J.L
Date:	06/11/27	Date:	06/12/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	27/ 9/11

DART AEROSPACE LTD	Work Order:	29511
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.439	0.439	0.439	0.446		
B	1.745	1.755		1.750	1.749	1.749	1.756		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.748	1.750		
E	7.990	8.010		7.996	7.998	7.998	7.998		
F	0.490	0.510		0.502	0.498	0.500	0.500		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.377	0.377		
I	0.490	0.510		0.498	0.498	0.500	0.498		
J	1.174	1.184		1.179	1.178	1.179	1.178		
K	0.558	0.578		0.568	0.569	0.568	0.565		
L	1.174	1.184		1.179	1.179	1.179	1.178		
M	1.490	1.500		1.495	1.495	1.495	1.494		
N	2.495	2.505		2.500	2.499	2.500	2.500		
O	3.869	3.879		3.872	3.872	3.872	3.873		
P	0.115	0.135		0.126	0.126	0.126	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.250	0.251	0.251		
S	0.115	0.135		0.133	0.133	0.129	0.132		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.961	2.960	2.960	2.961		
V	0.230	0.250		0.246	0.246	0.246	0.242		
W	0.115	0.135		0.125	0.126	0.133	0.135		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.364	0.365	0.364	0.366		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.629	0.629	0.630	0.630		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.246	0.246	0.248		
AE	1.375	1.395		1.380	1.381	1.387	1.384		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.257	0.265	0.260		
AH	0.240	0.260		0.269	0.248	0.249	0.249		
AI	2.000	2.020							
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	<i>one</i>	Audited by:	<i>JL</i>
Date:	<i>06/11/27</i>	Date:	<i>06/12/10</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JL</i> <i>JL</i>	

DART AEROSPACE LTD	Work Order:	29511
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	.439	.439	.435	.440		
B	1.745	1.755		1.756	1.750	1.750	1.748		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.748		
E	7.990	8.010		7.999	8.000	8.000	8.001		
F	0.490	0.510		.500	.500	.500	.499		
G	0.257	0.262	DT8683	.258	.258	.258	.259		
H	0.375	0.380	DT8684	.376	.376	.376	.377		
I	0.490	0.510		.498	.498	.498	.496		
J	1.174	1.184		1.179	1.179	1.179	1.176		
K	0.558	0.578		.567	.567	.568	.566		
L	1.174	1.184		1.179	1.179	1.179	1.176		
M	1.490	1.500		1.495	1.493	1.493	1.492		
N	2.495	2.505		2.500	2.500	2.500	2.499		
O	3.869	3.879		3.874	3.874	3.874	3.872		
P	0.115	0.135		.126	.125	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.251	.250		
S	0.115	0.135		.130	.130	.130	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.240	.241	.241		
W	0.115	0.135		.130	.129	.127	.127		
X	0.307	0.312		.311	.311	.311	.311		
Y	0.760	0.765		.761	.761	.761	.765		
Z	0.352	0.372		.364	.364	.364	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.629	.628	.629	.629		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.248	.248	.248		
AE	1.375	1.395		1.384	1.384	1.385	1.385		
AF	0.115	0.135		.134	.134	.134	.135		
AG	0.240	0.280		.250	.250	.250	.260		
AH	0.240	0.260		.247	.248	.248	.251		
AI	2.000	2.020							
AJ	0.023	0.043		.033	.033	.033	.030		
Accept/Reject									

Measured by:	SD	/	JK	Audited by:	JL
Date:	06/11/28	/	06/11/29	Date:	06/12/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JK JL

DART AEROSPACE LTD				Work Order:	29511
Description: Saddle, Fwd Inboard				Part Number:	D2572
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

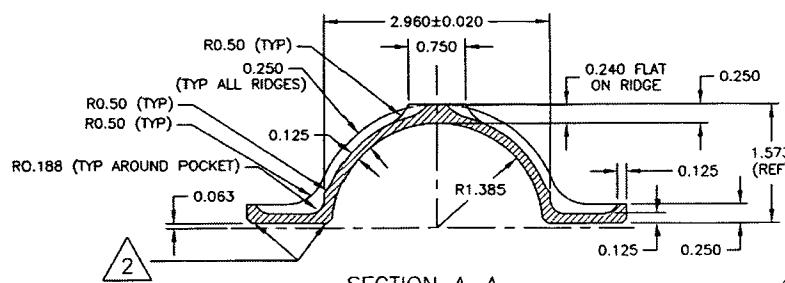
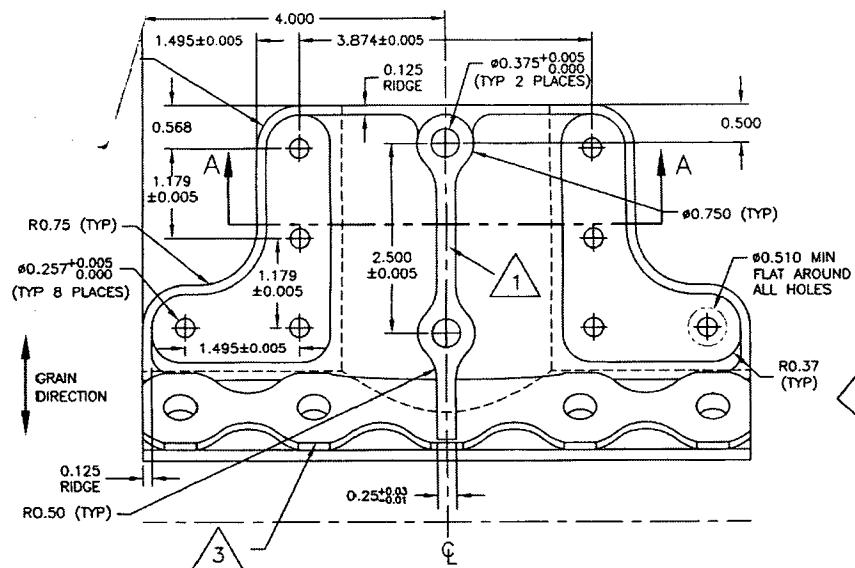
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.748	1.747	1.752	1.747		
C	3.495	3.505		3.497	3.499	3.502	3.500		
D	1.745	1.755		1.748	1.747	1.752	1.747		
E	7.990	8.010		8.002	8.000	8.003	8.002		
F	0.490	0.510		0.502	0.498	0.500	0.500		
G	0.257	0.262	DT8683	0.259	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.485	0.494	0.494	0.497		
J	1.174	1.184		1.175	1.176	1.175	1.178		
K	0.558	0.578		0.563	0.563	0.565	0.568		
L	1.174	1.184		1.175	1.176	1.175	1.178		
M	1.490	1.500		1.494	1.492	1.494	1.493		
N	2.495	2.505		2.499	2.498	2.494	2.498		
O	3.869	3.879		3.872	3.871	3.872	3.872		
P	0.115	0.135		0.126	0.126	0.126	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.250	0.249	0.250		
S	0.115	0.135		0.131	0.131	0.130	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.961	2.960	2.960		
V	0.230	0.250		0.239	0.237	0.241	0.240		
W	0.115	0.135		0.126	0.130	0.126	0.127		
X	0.307	0.312		0.311	0.310	0.311	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.367	0.364	0.365	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.628	0.628	0.626		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.249	0.246	0.249	0.246		
AE	1.375	1.395		1.383	1.385	1.384	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.248	0.248	0.249	0.248		
AI	2.000	2.020							
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	SJ	/ En	Audited by:	JL
Date:	06.11.2011	06/11/11	Date:	06/12/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
	05.05.05	Added dimension AI	KJ/RF	
	2.05	Added dimension AJ	KJ/JLM	JL

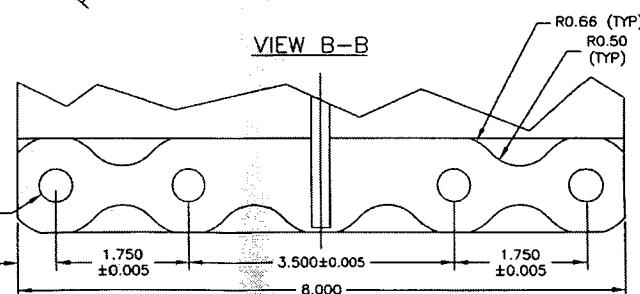
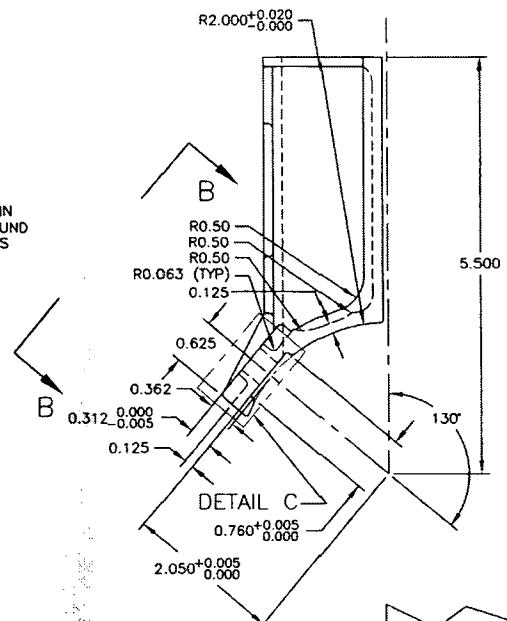
RELEASED

05.12.06



SECTION A-A

DETAIL C  
SCALE 2:1



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
DS	PH	
CHECKED	APPROVED	DRAWING NO. D2572
		REV. E SHEET 1 OF 1
DATE	TITLE	SCALE
05.07.13	INNER FWD SADDLE	2:3

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL  
AND IS SUPPLIED ON THE EXPRESS CONDITION  
THAT IT IS NOT TO BE REPRODUCED IN ANY PURPOSE  
OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

SHOP COPY  
RETURN TO  
ENGINEERING  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
WITHOUT NOTICE  
WORK ORDER  
NO. 29511